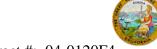
#### **DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

## WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-008156 Address: 333 Burma Road **Date Inspected:** 31-Jul-2009

City: Oakland, CA 94607

**OSM Arrival Time:** 645 **Project Name:** SAS Superstructure **OSM Departure Time:** 1845 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**CWI Name:** Liu Xiaozhong, Xu Le Feng, Zhang Wili Peresent: Yes No

**Inspected CWI report:** Yes No N/A **Rod Oven in Use:** Yes No N/A N/A **Weld Procedures Followed: Electrode to specification:** Yes No Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No No N/A

Yes **Delayed / Cancelled:** 

34-0006 **Bridge No: Component: Tower Components** 

#### **Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay11, Lift 4, Skin C, West Tower.

FCAW welding of weld joint WSD1-FCSA4-2C/C-19, 20, 5, 6 & WSD1-FCSA4-2B/C-5, 6; located on Bay 11, Lift 4, Skin C, West Tower. Welder is identified as 69712, 67501, 070008, 069469, 070022, 67550; ZPMC Quality Control Inspector (QC) is identified as Liu Xiaozhong. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2332-TC-P5-F.

Bay11, Lift 4, Skin C, West Tower.

FCAW welding of weld joint WSD1-FCSA4-2B/C-1B & WSD1-FCSA4-2C/C-15B; located on Bay11, Lift 4, Skin C, West Tower. Welder is identified as 040759, 047701; ZPMC Quality Control Inspector (QC) is identified as Zhang Zhineng. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U5-F.

Bay11, West Tower, Angle Plate.

SAW welding of weld joint SD1-A5002-1-1A & SD1-A5002-2-1A & SD1-A5002-3-1A & & SD1-A5002-4-1A; located on Bay11, West Tower. Welder is identified as 042195 Yang Meizhen; ZPMC Quality Control Inspector (QC) is identified as Xu Le Feng. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-3221-U5B-S-1.

## WELDING INSPECTION REPORT

(Continued Page 2 of 3)

#### This QA Inspector carried out NDE on following:

#### Bay 11, West Tower, Lift 1.

This QA inspector performs Random Visual Testing (VT) of area previously tested and accepted by ZPMC Quality Control personnel. The members are identified as

- 1) WSD1-A423E/H-50 TO 65. 9M Diaphragm to Skin A Fit Lugs.
- 2) WSD1-A423E/H-170 TO 185. 13M Diaphragm to Skin A Fit Lugs.
- 3) WSD1-A423F/H-27 TO 34. 15M Diaphragm to Skin A Fit Lugs.
- 4) WSD1-A423F/H-79, 73. 15M Diaphragm to Skin A Welds.
- 5) WSD1-A423E/H-186. 13M Diaphragm to Skin A Welds.
- 6) WSD1-A423E/H-117. 9M Diaphragm to Skin A Welds.

#### Bay 11, West Tower, Plange of Strut Plates.

This QA inspector performs Magnetic Particle Testing (MT) of approximately 15% area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as

- 1) WD1-A6001-1-3A/B.
- 2) WD1-A6001-2-1A/B.
- 3) WD1-A6001-1-4A/B.
- 4) WD1-A6001-2-2A/B.
- 5) WD1-A6001-3-4A/B.
- 6) WD1-A6001-4-4A/B.
- 7) WD1-A6001-4-2A/B.
- 8) WD1-A6001-5-4A/B.
- 9) WD1-A6001-5-2A/B. 10)WD1-A6001-3-3A/B.
- 11)WD1-A6001-4-1A/B.
- 12)WD1-A6001-4-3A/B.
- 13)WD1-A6001-5-1A/B.
- 14)WD1-A6001-5-3A/B.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

# **Summary of Conversations:**

No relevant conversations.

#### **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 13482570045, who represents the Office of Structural Materials for your project.

# WELDING INSPECTION REPORT

(Continued Page 3 of 3)

**Inspected By:** Juvekar, Amit Quality Assurance Inspector

**Reviewed By:** Clifford,William QA Reviewer